

5/20

23524

DART AEROSPACE LTD		Work Order:	23524
Description: Pedal Assembly		Part Number:	D3204-041
Dwg: D3204 Rev. A		Qty:	4/10
			Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travelers for: D3204-041 Pedal Assembly D3204-1 Tube D3204-7 Bushing Dwg not required	23524 Batch 23524 23524 23524 23524 23524 23524	KJ	05.07.6
2	MV	Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.500x02.000) Identify for D3204-3	Batch: M17037	SD	05.07.07 10
3	MV	Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.375x01.250) Identify for D3204-5	Batch: M7321	SD	05.07.07 10
4	MV	Cut blank: 1.00" x 0.500" x 1.150" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.500x01.000) Identify for D3204-11	Batch: M10973	SD	05.07.07 10
5	MV	Cut blank: 2.000" x 0.375" x 3.100" long Bar Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.375x02.000) Identify for D3204-9	Batch: M5185	SD	05.07.07 10
6	MV	Machine D3204-3 as per Folio FA344 and Dwg D3204 Identify as D3204-3		SD	05.07.07 10
7	QC2	Inspect parts as they come off the CNC machine		SD	05.07.07 10
8	MV	Deburr		SD	05.07.07 10
9	QC8	Second check		E	05.07.08 10
10	MV	Machine D3204-5 as per Folio FA344 and Dwg D3204 Identify as D3204-5		SD	05.07.08 10
11	QC2	Inspect parts as they come off the CNC machine		SD	05.07.08 10
12	MV	Deburr		SD	05.07.08 10
13	QC8	Second check		E	05.07.08 10
14	MV	Machine D3204-11 as per Folio FA357 and Dwg D3204 Identify as D3204-11		SD	05.07.08 10
15	QC2	Inspect parts as they come off the CNC machine		SD	05.07.08 10
16	MV	Deburr		SD	05.07.08 10
17	QC8	Second check		E	05.07.08 10
18	MV	Machine D3204-9 as per Folio FA357 and Dwg D3204 Identify as D3204-9		BG	05.07.09 10
19	QC2	Inspect parts as they come off the CNC machine		BG	05.07.09 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

23524

DART AEROSPACE LTD	Work Order:	23524
Description: Pedal Assembly	Part Number:	D3204-041
Dwg: D3204 Rev. A	Qty:	4

Page 2 of 2

Step	Location	Procedure	By	Date	Qty
20	MV	Deburr	BG	05.07.09	10
21	QC8	Second check	SP	05/07/09	10
22	WA	Cut (2) D3204-13 per Assembly Cut blanks as per Dwg D3204 Material: 6061-T6 (QQ-A-250/11) 0.125" thick (M6061T6S.125) Identify as D3204-13	Batch: M11946	CPL	05.07.15 10
23	WA	Grind hypotenuse side	CPL	05.07.15	10
24A	WA	Weld assembly as per Dwg D3204 using Jig D3204-041T1 Pick: D3204-1 Qty Part Number Description 1 D3204-1 Tube Identify as D3204-041	-1 B23524 -3 B23524 -5 B23524 -9 B23524 -11 B23524	CPL	05.07.15 10
25	QC5/9	Inspect weld	2	05.07.18	10
26	FP	Chemical Conversion Coat as per QSI 005 4.1	PM	05-7-18	10
27	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 D3204-041 Note: Cover holes for bushing	FC	050729	10
28	QC3	Inspect Powder Coat	AB	050729	10
29	GA	Install D3204-7 bushing as shown in Dwg D3204 Pick: Qty Part Number Description Batch 2 D3204-7 Bushing B23524 ml 05/08/03	ml	05/08/03	10
30	QC5	Inspect work to Step 29	2	05-08-05	10
31	ST	Identify and Stock D3204-041 Qty: 10 D3204-1 Qty: 0 D3204-7 Qty: 4 ml 05/08/10 Note: D3204-1/-7 are stocked in welding cell	2	05/08/10	10
32	AC	Parts to Stock and Prorate Cost to parts per Step 31 Cost / part 84.77	SAC	05-08-26	10
33	DC	Close W/Order and Ensure Travelers attached Inspect Level 21 89.77 Travelers: D3204-041 D3204-1 D3204-7	10	05/08/11	10

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Added Travelers	KJ/RF	#F

24B	WA	DRILL #40 DIA HOLE IN CENTER OF Φ 0.760" BORE ON D3204-5 ARM PRIOR OF WELD. USE J.B. WELD COMPOUND TO PLUG THE HOLE AFTER ASSEMBLY. GRIND FLUSH J.B. WELD AFTER IT IS CURE.	CPL	05.07.15
			RELEASED	HF 04.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
07/06	24	Permanent change L	L		1	J	6-07-18

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	23524
Description: Arm	Part Number:	D3204-3
Inspection Dwg: D3204	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>SD</u>	Audited by:	<u>E</u>	Prototype Approval:	N/A
Date:	05.07.07	Date:	05.07.07	Date:	N/A

<u>Rev</u>	<u>Date</u>	<u>Change</u>	<u>Revised by</u>	<u>Approved</u>
A	05.02.17	New Issue (P/O D3204-041)	KJ/JLM	CJF

H:\FORMS\Quality Assurance\approved QA\FAI revD¹

RELEASED
01/05/2021

DART AEROSPACE LTD	Work Order:	23524
Description: Arm	Part Number:	D3204-5
Inspection Dwg: D3204	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>SD</u>	Audited by:	<u>EC</u>	Prototype Approval:	N/A
Date:	05.07.08	Date:	05.07.08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3204-041)	KJ/JLM	LL

RELEASED BY
11/05/2027

DART AEROSPACE LTD	Work Order:	23524
Description: Pedal	Part Number:	D3204-9
Inspection Dwg: D3204	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>BS</i>	Audited by:	<i>CR</i>	Prototype Approval:	N/A
Date:	05-07-09	Date:	05/07/09	Date:	N/A

<u>Rev</u>	<u>Date</u>	<u>Change</u>	<u>Revised by</u>	<u>Approved</u>
A	05.02.17	New Issue (P/O D3204-041)	KJ/JLM	

RELEASED
11/05/2023

DART AEROSPACE LTD	Work Order:	23524
Description: Plate	Part Number:	D3204-11
Inspection Dwg: D3204	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>SD</u>	Audited by:	<u>EC</u>	Prototype Approval:	N/A
Date:	05.07.08	Date:	05-07-08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3204-041)	KJ/JLM	<i>[Signature]</i>

RELEASED
July 25, 2022

Job Costing Report

Dart Aerospace Ltd.
HawkesburyJun 07, 2005
11:56 am

Work Order No : 0023524
 Project Name : D3204-041
 Project For : WK526
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3204-041
 Description : Pedal Assembly
 Manufactured : Yes
 Amount Req'd : 4
 Amount Done : 0
 Start Date : 06-07-05
 Est Finish Date : 06-30-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

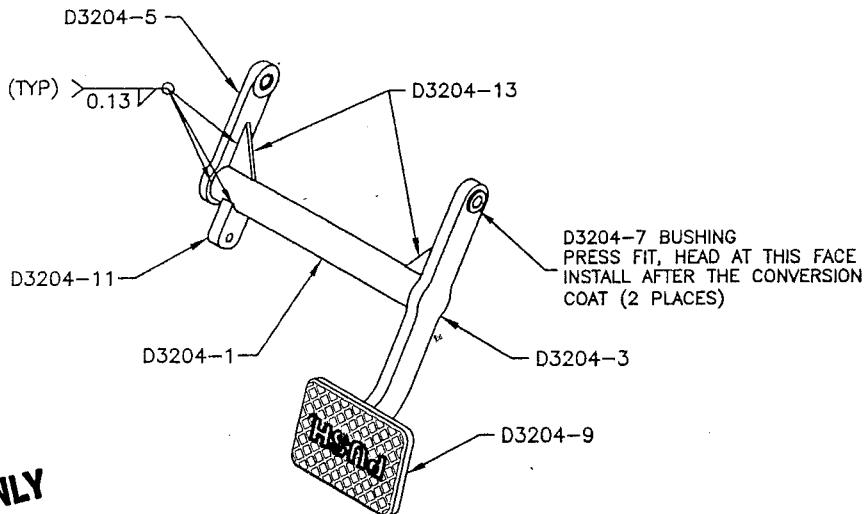
CONFIDENTIAL COPY



MAILED COPY

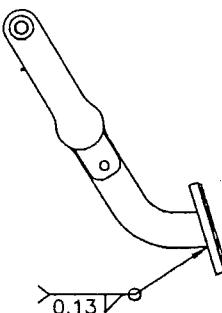
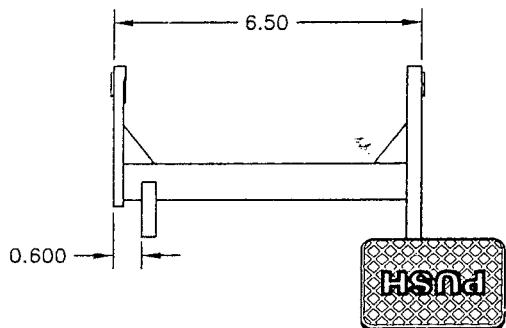
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	

RELEASED
04.01.30



REFERENCE ONLY

REFERENCE ONLY



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD X 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

5/26

DART AEROSPACE LTD	Work Order:	23524
Description: Tube	Part Number:	D3204-1
Dwg: D3204 Rev. A page 2	Qty:	24
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	JG	05.06.08	24
2	MC	Turn D3204-1 tube as per Folio FA356 and Dwg D3204 Material: 6061-T6/-T62 (QQ-A-200/8) Ø0.750" x 0.125" wall (M6061T6T0.750W.125) Identify for D3204-1	M 13848 Batch: M 15972	JG	05/07/07 24
3	QC2	Inspect parts as they come off the CNC machine Identify as D3204-1	JG	05/07/08	24
4	MC	Deburr	JG	05/07/08	24
5	QC8	Second check	RE	05/07/08	24
6	MC	Go to D3204-041 for welding	✓	CPK	05.07.15 24

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Change Step 6; remove Steps 7 & 8	KJ/RF	RF

RELEASED

RF 04-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	23524
Description: Tube	Part Number:	D3204-1
Inspection Dwg: D3204	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.G	Audited by:	E	Prototype Approval:	N/A
Date:	05/07/08	Date:	05.07.08	Date:	N/A

Rev	Date	Change	Revised by	Approved
. A	05.02.17	New Issue (P/O D3204- 1)	KJ/JLM	10/02/17

RELEASER
11/25/2022

DART AEROSPACE LTD	Work Order:	23524
Description: Bushing	Part Number:	D3204-7
Dwg: D3204 Rev. A page 2	Qty:	24
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	KJ	05.06.08	24
2	MC	Turn D3204-7 bushing as per Folio FA355 and Dwg D3204 Material: AISI 303 SS Ø0.50" (M303R0.500) Identify for D3204-7 Batch: M16719	YD	05/08/02	24
3	QC2	Inspect parts as they come off the CNC machine Identify as D3204-7	YD	05/08/02	24
4	MC	Deburr	YD	05/08/03	24
5	QC8	Second check	YD	05/08/03	24
6	MC	Go to D3204-041 for assembly	MJ	05/08/03	24

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Change Step 6; remove Steps 7 & 8	KJ/RF RF	RF

RELEASED

RF 04.06.21

Chase
7/7/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	23524
Description: Bushing	Part Number:	D3204-7
Inspection Dwg: D3204 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	YD	Audited by:	BSG	Prototype Approval:	N/A
Date:	05/08/02	Date:	05.08.02	Date:	N/A

Rev	Date	Change	Revised by	Approved
.A	05.02.17	New Issue (P/O D3204-7)	KJ/JLM	[Signature]

H:\FORMS\Quality Assurance\approved QA\FAI revD

RELEASED
10/6/2027